

Date: Tuesday, 06/05/2008 8:54:47 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : A119 STEP INSTALLATION L/H
<b>Job Number</b> : 39067	
<b>Estimate Number</b> : 10126	
<b>P.O. Number</b> :	<b>Part Number</b> : D119675011
<b>This Issue</b> : 06/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : IIN 119-675 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 36578	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/05/2008 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.5.06</u>	
<b>Comment</b> : Est Rev:D Removed Manufacturing JLM 05-11-01 Est RevE change at rev.b as per ECN1107 DD verified by:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	39067A	A119 STEP WELDMENT LH



**Comment:** Sub-Component A119 STEP WELDMENT LH

02/05/22

08.05.07

2.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
 Photocopy bluefile & type labels per PPP 119-675011 CHG003

08.05.07

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick: Packing Kit

4.0	D2182B032	Rubber Cushion
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty	Part Number	Description	Batch
4	D2182B032	Rubber Cushion	

37632  
35769

AS 08/05/08 (XS)

5.0	D2274	Radius Block
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:Packing Kit

Qty	Part Number	Description	Batch
8	D2274	Radius Block	

B37630

AS 08/05/08 (XS)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/05/08	#4 E 8	Please indicate in this manner. 4 x D2732-032 (4x32" per unit).					08/05/08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 8:54:47 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION L/H

Job Number: 39067

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26173

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing

B29991

KS 08/05/08 (X5)

7.0

D26175

Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing

39082

KS 08/05/08 (X5)

8.0

D2732032

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Qty Part #

Description

Batch

4 D2732-032

Rubber cushion

B37632

KS 08/05/08 (X5)

9.0

D30411

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3041-1 Clamp

35978 x15  
B26217 x1

KS 08/05/08 (X5)

10.0

D30413

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp

B35979 x10  
~~B26217 x1~~  
~~B35978 x5~~

KS 08/05/08 (X5)

OK from DAVID  
for Rubber cushion Qty

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION L/H

Job Number: 39067

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D30421

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3042-1 Clamp B35982

JS 08/05/08 (XS)

12.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt M105143

JS 08/05/08 (XS)

13.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt 104214

All same Batch enough in comp. Not take out other BP.

JS 08/05/08 (XS)

14.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt M107321

JS 08/05/08 (XS)

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M107321

JS 08/05/08 (XS)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 8:54:48 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION L/H

Job Number: 39067

Part Number: D119675011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

1 paperwork package from Step 1

M16051

JS 08/05/08 (X5)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 08/05/22 (X5) (41)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-011

Location: C

8/5/02

scf

(5x)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/26

Job Completion



mf 08-05-23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.5 lb	- 32.4 in	- 373 in-lb	121.3 in.	1395 in-lb
<i>HELI-ACCESS-STEP™</i> , LH	5.2 kg	- 1.28 m	- 6.7 m-kg	3.08 m	16.0 m-kg
D119-675-012	11.5 lb	+32.4 in	+373 in-lb	121.3 in	1395 in-lb
<i>HELI-ACCESS-STEP™</i> , RH	5.2 kg	+1.28 m	+6.7 m-kg	3.08 m	16.0 m-kg

## 5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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 NO. 39067

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Revision: **B**  
 Date: 07.10.23